

Date: Thursday, 15/01/2009 11:23:40 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SEAT RAIL
 Job Number : 44832
 Estimate Number : 13533
 P.O. Number :
 This Issue : 15/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38081
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3808 REV A
 Previous Run : 44197 Drawing Revision : A
 Material :
 Due Date : 10/02/2009 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : JLD 09.01.15
 Comment : Est Rev:A New Issue 08-07-31 JLM Verified By:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 -M6061T6B2000X01250 6061-T6 Bar 2.00 x 1.25



Comment: Qty.: 1.4175 f(s)/Unit Total: 17.0100 f(s)

6061-T6 Bar 2.00 x 1.25

Batch: M109223

JLD 09/01/21

2.0 BAND SAW BAND SAW



(12)

Comment: BAND SAW

Cut blank 16.125" long

JLD 09/01/21

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



(12)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA771 Rev: AA & Dwg D3808 Rev: A

2-Tap holes for 8-32" Helicoil

3-Tap holes for 3/8-16 Helicoil

4-Deburr per dwg D3808

JLD / H.A 09/01/22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



(12)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/01/22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 11:23:40 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT RAIL

Job Number: 44832

Part Number: D38081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/01/23

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSP005 4.1

09-01-26

(12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 255*

JS 09/01/26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 JS

Job Completion



U 09.01.26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44832
Description: Seat rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

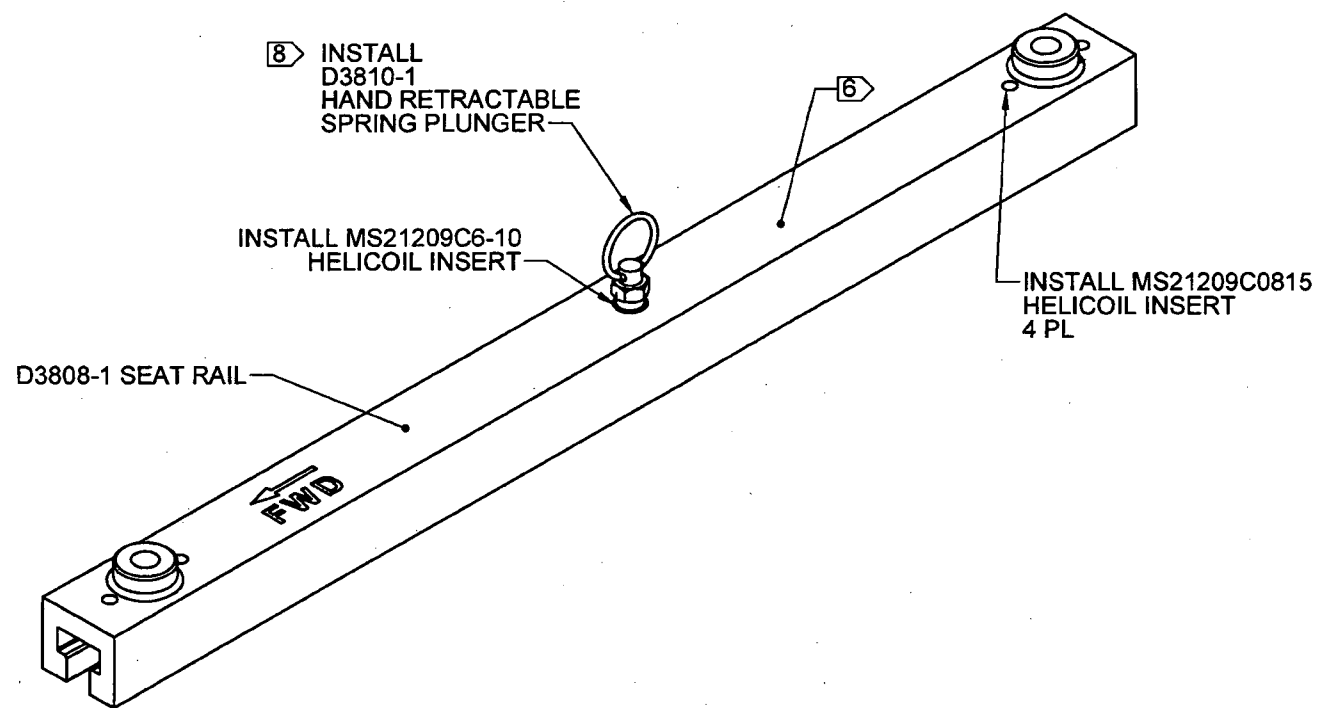
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.965	$\pm .010$.963	✓			
.375	$\pm .010$.373	✓			
1.10	$\pm .030$	1.101	✓			
.347	$\pm .010$.345	✓			
.03x45°	$\pm .010 \pm .5^\circ$.03x45°	✓			
.350	$\pm .010$.350	✓			
.655	$\pm .015$ $\pm .010$.663	✓			
.320	$\pm .020$ $\pm .0$.323	✓			
.063	$\pm .010$.063	✓			
.720	$\pm .015$ $\pm .010$.720	✓			
.270	$\pm .030$ $\pm .0$.270	✓			
Ø.323	$\pm .005$ $\pm .001$.325	✓			
.695x100°	$\pm .010 \pm .5^\circ$.693x100°	✓			
.800	$\pm .010$.801	✓			
.667	$\pm .010$.670	✓			
.140	$\pm .010$.141	✓			
.06	$\pm .03$.062	✓			
.373	$\pm .010$.372	✓			
15.88	$\pm .030$	15.88	✓			
Ø.172	$\pm .005$ $\pm .001$.172	✓			
Ø.391	$\pm .005$ $\pm .001$.391	✓			
2.00	$\pm .030$	2.002	✓			
6.13	$\pm .030$	6.125	✓			

Measured by: J.L./K.A.M./11 ²²	Audited by: J.L.	Prototype Approval:	N/A
Date: 09/01/21	Date: 09/01/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

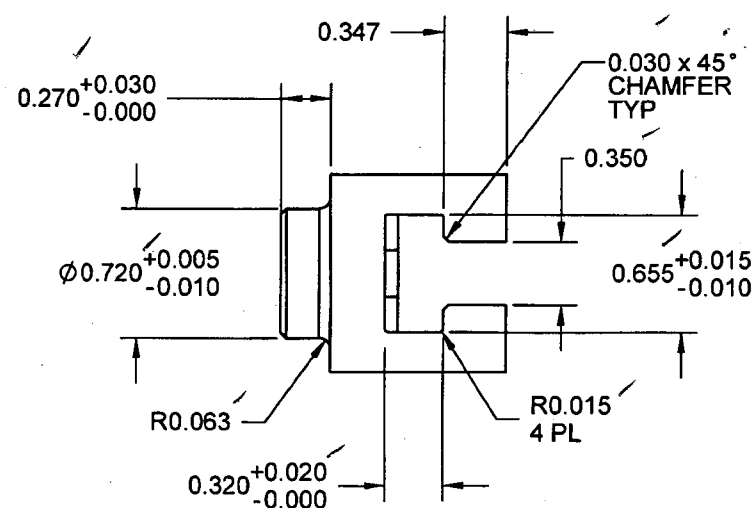
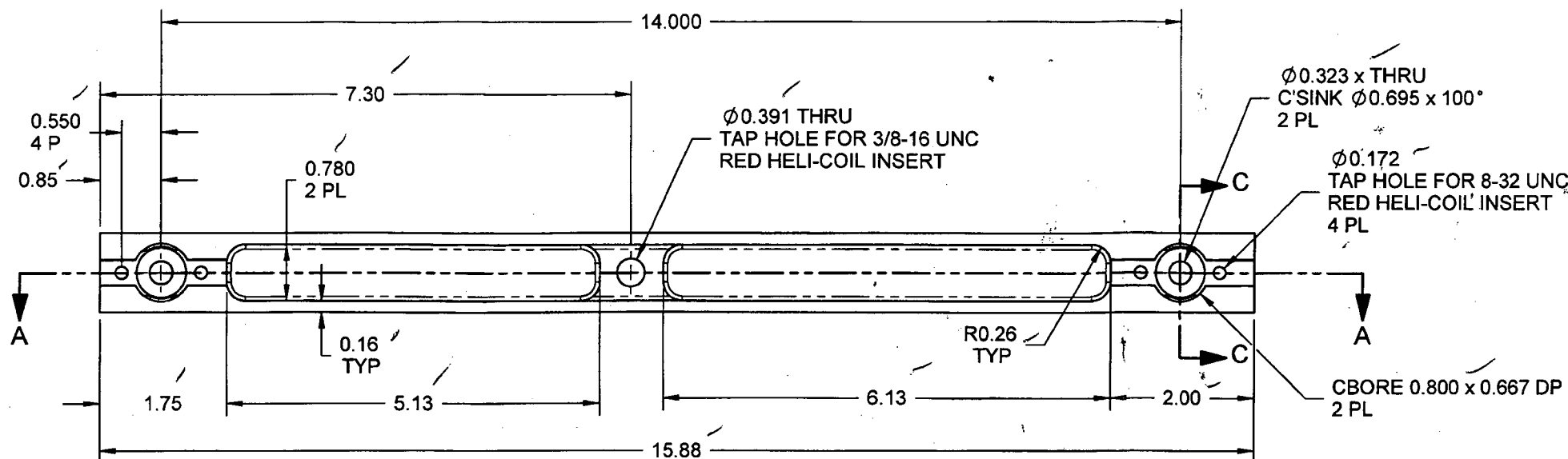
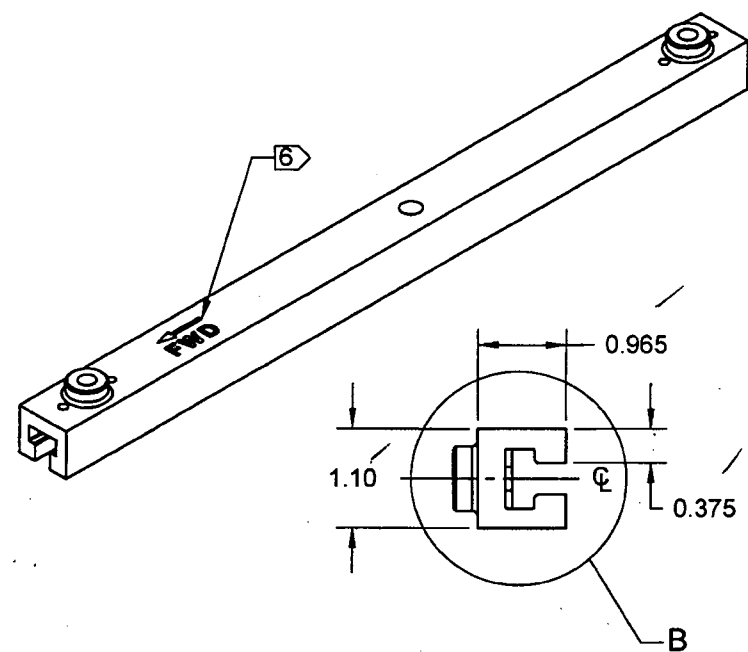
D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

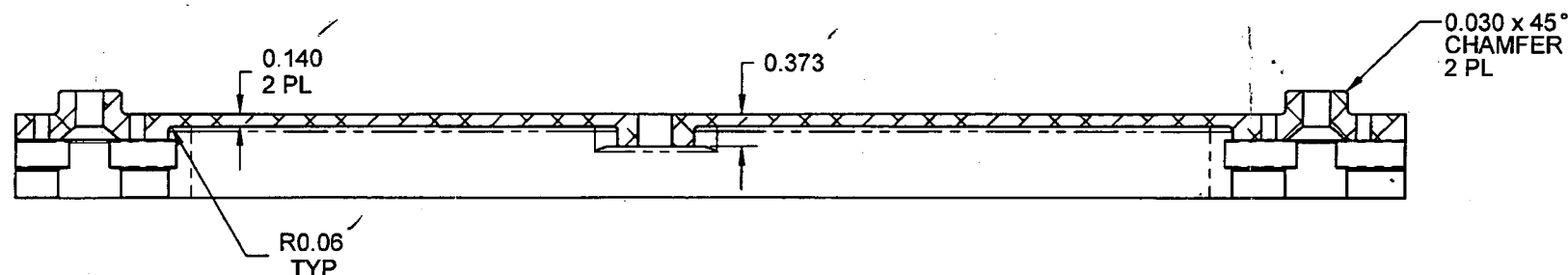
RELEASED
08-09-30/11

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44832

A	NEW ISSUE	RF	08.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
DATE	08.08.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

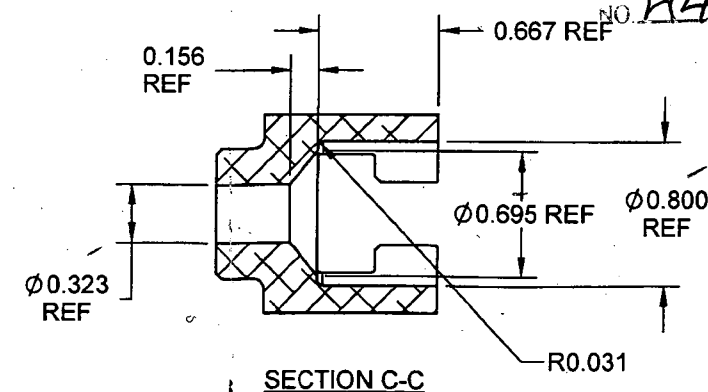


DETAIL VIEW B



SECTION A-A

D3808-1 SEAT RAIL



SECTION C-C

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **H4832**

RELEASED
08-03-08

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
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